

Work Order ID 72784

Friday, August 12, 2011 2:38:30 PM



Page 1

Item ID: D206-642-241

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 8/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *11*

Date: *11-08-12* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

0.00



DOCUMENT CONTROL

0.00

DC

Memo

Document Control

Photocopy bluefile & type labels per PPP D206-642-241

CHG005

N/A *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650								
	3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. Pick: Qty <input type="checkbox"/> Part Number <input type="checkbox"/> Description <input type="checkbox"/> Batch A/R <input type="checkbox"/> Aluminum Rod <input type="checkbox"/> M112860								
	4-Grind weld flush to cap on top surface only.								
	5-Cut Aft end as per dwg 2650 from front of tube and Deburr								
	6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650								
	7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.								
	8-Drill pilot holes using Dt 8167.								
	9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.								
	10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.								

MO/DP

11-09-15

BE 11/09/15

BE 11/07

Dart Aerospace Ltd

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D2650

15-C'sink GHW rivet holes as per Dwg D2650

BEH/07

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Sulu/08

(H)

Dart Aerospace Ltd

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Skidtubes

Skidtubes

0.00

Memo

0.00

1-Open crossbolt holes to Ø0.3125"

2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650.
Open Aft cap hole #6.

3-Deburr tube and blow out chips from inside the tube

1 0 BE 11/11/08

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

1 0 BE 11/11/08

150



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

0 0 SAD 11/11/08

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Skidtubes	Skidtubes	0.00				1	0		BE 11/1/08
Skidtubes	Memo	0.00							
	1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								
170 QC	QC6- Inspect dimensions to drawing	0.00							
Quality Control	Memo	0.00							

DP 11-11-9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

180

0.00

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: ☐ 11/10/09 ☐ Time: ☐ 3:20 ☐

Finish Date: ☒ 11-11-10 ☐ Time: ☒ 2:00

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch
A/R ☐ ☐ Sikaflex-291 ☐ 119399 ☐ ☐
Sikaflex expire date: ☐ 12/08/13

190

QC5- Inspect part completeness to step on W/O

0.00

OC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00



Skidtubes

Skidtubes

Memo

0.00

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Aluminum Rod ☒ M117084

3-Grind welds flush as per Dwg D2650.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☒ NONE

5-Counterbore 5/16" x 0.750" deep except 7th hole from AB end as per Dwg D2650. Deburr

> BE 11-11-10

BE 11-11-14

11-11-14

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Dart Aerospace Ltd

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Stop

[illegible][illegible]

Customer:

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp. Stamp

0.00

[illegible]

Memo

0.00

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

0.00

[illegible]

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE: _____

FINISH TIME:

0.00

260

0.00

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270 	HandFinishing	0.00							
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/R <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> <input type="checkbox"/> <u>119443</u> <input type="checkbox"/> <input type="checkbox"/> Sikaflex expire date: <u>12-1</u>								
	2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650 (D2650-3 detail). Clean excess adhesive.								
	3-Install MS27039-4-06 Screw as per DEO 9153.								
	4 -Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/R <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> <input type="checkbox"/> <u>118445</u> <input type="checkbox"/> <input type="checkbox"/> Sikaflex expire date: <u>12-1</u>								
	5 -Wing Walk as per Dwg D2650-3 and QSI 005 4.4 A/R Batch: <u>118988</u> Batch: <u>12-1</u>								
300 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

1 BX 11-11-16

S u/w/16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
310		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-664-241								
	Location: _____								
	PPP Rev: _____								
320		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

11/11/28

11/11/28

CME
11-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube



Start Date: 8/12/2011

Start Qty: 1.00

Required Date: 8/19/2011

Required Qty: 1.00

Comments: IPP Rev: 04.12.02 ☐ Revised procedural steps ☐ KJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verified by:EC ☐ IPP rev Q 10.02.19 per PAR 09-043 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620 		Manufactured	No			110	Each	18.0000	1	1			
Skidtube, 206 Skidtube													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		18							
				68136		1							
				71616		5							
				71617		12							
D3286-1 		Manufactured	No			110	Each	32.0000	2	2			
Doubler													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002		32							
				52844		11							
				64563		21							
D2647 		Manufactured	No			110	Each	44.0000	1	1			
Cap													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002		44							
				55352		14							
				71171		30							

① 11-9-15
BEN/07
B74441 22
BEN/09/15

Dart Aerospace Ltd

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Start Date: 8/12/2011

Required Date: 8/19/2011

Start Qty: 1.00

Required Qty: 1.00

D2654-3 Manufactured No

180 Each 4.0000 1 1



Web



Location

Loc Qty

Loc Code

LG

4

1

64876

4

CR3212-4-04 Purchased No

180 Each 555.0000 52 52



Cherry Rivet



Location

Loc Qty

Loc Code

ST311

555

53

116471

78

117816

477

D2649 Manufactured No

200 Each 130.0000 18 18



Cross Bolt Spacer



Location

Loc Qty

Loc Code

LG

118

68224

2

71355

2

72704

114

LG001

12

65317

1

68507

11

D3286-3 Manufactured No

200 Each 27.0000 2 2



Spacer



Location

Loc Qty

Loc Code

LG002

27

64564

27

PL 11/11/09

PL 11/11/09

BE 11-11-10

B 73855 *18

BB 11-11-11

B 74439 *18

Dart Aerospace Ltd

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Start Date: 8/12/2011

Required Date: 8/19/2011

Start Qty: 1.00

Required Qty: 1.00

D2680-041 Manufactured No

210 Each

19.0000 1 1



Nut Plate



DP 11-11-14

Location

Loc Qty

Loc Code

ST020

73854

19

①

55366

17

70088

2

CR3212-4-03

Purchased No

210 Each

1,174.000 2 2



Cherry Rivet



DP 11-11-14

Location

Loc Qty

Loc Code

FP-B

110139

2

②

ST311

114859

1172

1172

CCR264SS3-3

Purchased No

210 Each

471.0000 2 2



Cherry Rivet



DP 11-11-14

Location

Loc Qty

Loc Code

FP-B

113973

2

ST311

117086

469

117849

43

426

②

Dart Aerospace Ltd

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Start Qty: 1.00

Required Qty: 1.00

D2646 Manufactured No

270

Each

101.0000

1

1



Aft Cap



BR 11-11-16.

Location

Loc Qty

Loc Code

FP004

73825.

54

68280

54

FP006

5

62678

5

FP-4

38

70945

1

71070

37

fp5

4

71038

4

D2651-1

Manufactured No

270

Each

289.0000

18

18



Plug



BR 11-11-16.

Location

Loc Qty

Loc Code

fpa

73827

109

69018

109

FP-A

180

57869

1

66445

10

67760

36

70691

100

70839

2

71037

31

AN960JD416

*

NAS1149D0463J

Purchased

No

270

Each

0.0000

1

1



Washer



118384.

BR 11-11-16.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 12, 2011 2:38:37 PM

Work Order ID: 72784



Parent Item: D206-642-241



Parent Item Name: Replacement Skidtube

Start Date: 8/12/2011

Required Date: 8/19/2011

Start Qty: 1.00

Required Qty: 1.00

D2651-3 Manufactured No

270 Each

294.0000 18 18



O-Ring

Location

Loc Qty

Loc Code

FP-A

73489

294

61962

12

66956

282

18.

MS27039-1-08 Purchased No

270 Each

902.0000 46 46



Screw

Location

Loc Qty

Loc Code

ST291

902

115108

202

117423

300

118378

400

46.

ALS4-1032-130 Purchased No

270 Each

2,276.000 44 44



Insert

Location

Loc Qty

Loc Code

ST281

378

117331

8

118386

370

ST282

1898

117717

54

118237

1588

118312

256

* ALS7-1032-130

119530.

44. BR 11-11-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 12, 2011 2:38:37 PM

Work Order ID: 72784

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 8/12/2011

Required Date: 8/19/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

270

Each

37.0000

1

1



Screw



BR 11-11-16

Location

Loc Qty

Loc Code

FP-A

119075

8

115460

8

ST292

29

115460

29

AN960JD10L

NAS1149D0332 ✓ Purchased

No

270

Each

0.0000

46

46



Washer

117087



46

BR 11-11-16

D3537-1

Manufactured

No

270

Each

27.0000

4

4



Wearpad



BR 11-11-16

Location

Loc Qty

Loc Code

FP

74486

20

71574

20

FP017

7

69817

5

70686

2

D3537-3

Manufactured

No

270

Each

23.0000

1

1



Wearpad



BR 11-11-16

Location

Loc Qty

Loc Code

FP

72144

17

70481

17

FP017

6

35697

1

72686

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 12, 2011 2:38:37 PM

Work Order ID: 72784

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 8/12/2011

Required Date: 8/19/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-13

Manufactured No

270

Each

1.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP018

72786

1

65930

1

D3536-13

Manufactured No

270

Each

9.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP011

70030

9

70463

9

D3535-21

Manufactured No

270

Each

15.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP018

65788

15

70380

1

70461

8

D3536-21

Manufactured No

270

Each

14.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP011

61684

14

70464

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 12, 2011 2:38:37 PM

Work Order ID: 72784

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 8/12/2011

Required Date: 8/19/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-33

Manufactured No

270

Each

18.0000

1

1



Wearshoe



BR 11-11-16

Location

Loc Qty

Loc Code

FP019

18

70383 ✓

8

70462

10

1

D3536-33

Manufactured No

270

Each

26.0000

1

1



Gasket



BR 11-11-16

Location

Loc Qty

Loc Code

FP012

26

70382 ✓

10

70465

16

1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER -
NO. 72784

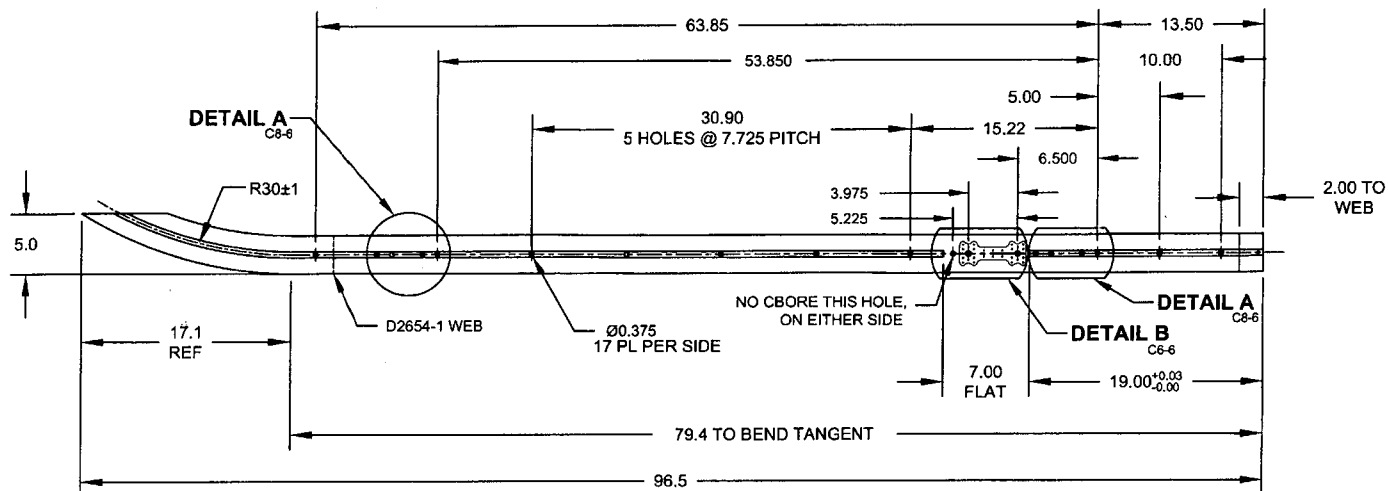
PL 11-88-12

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08-07-23

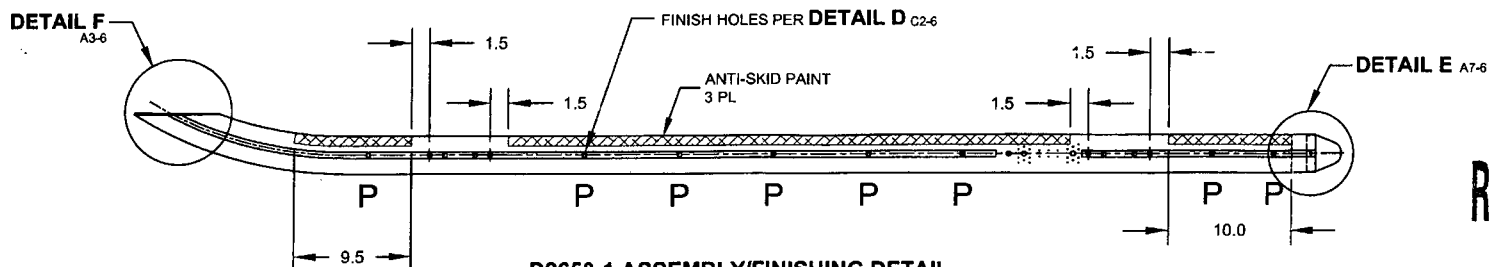
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D2650	REV. F
MFG. APPR.	<i>[Signature]</i>		SHEET 1 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
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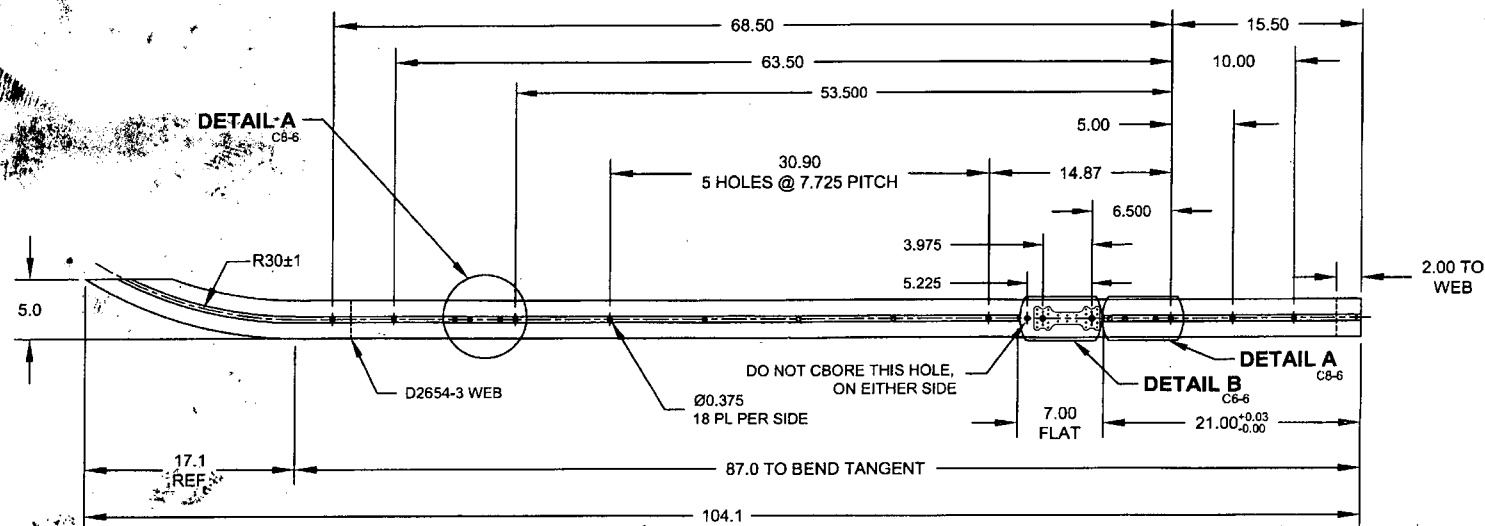
D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

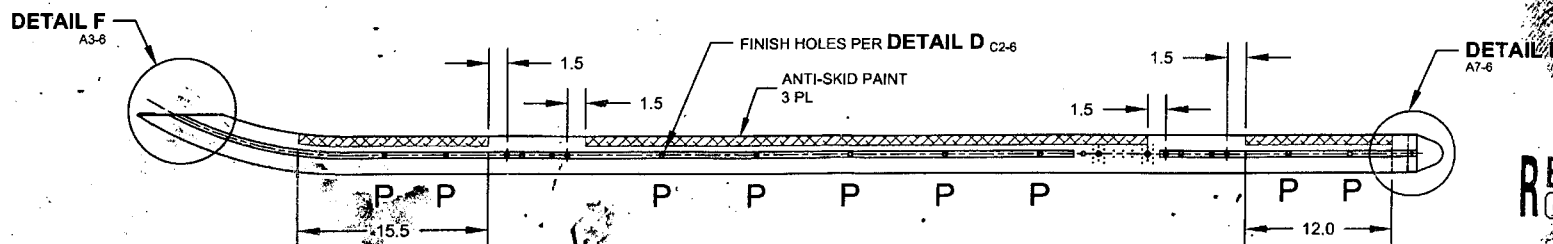
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DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
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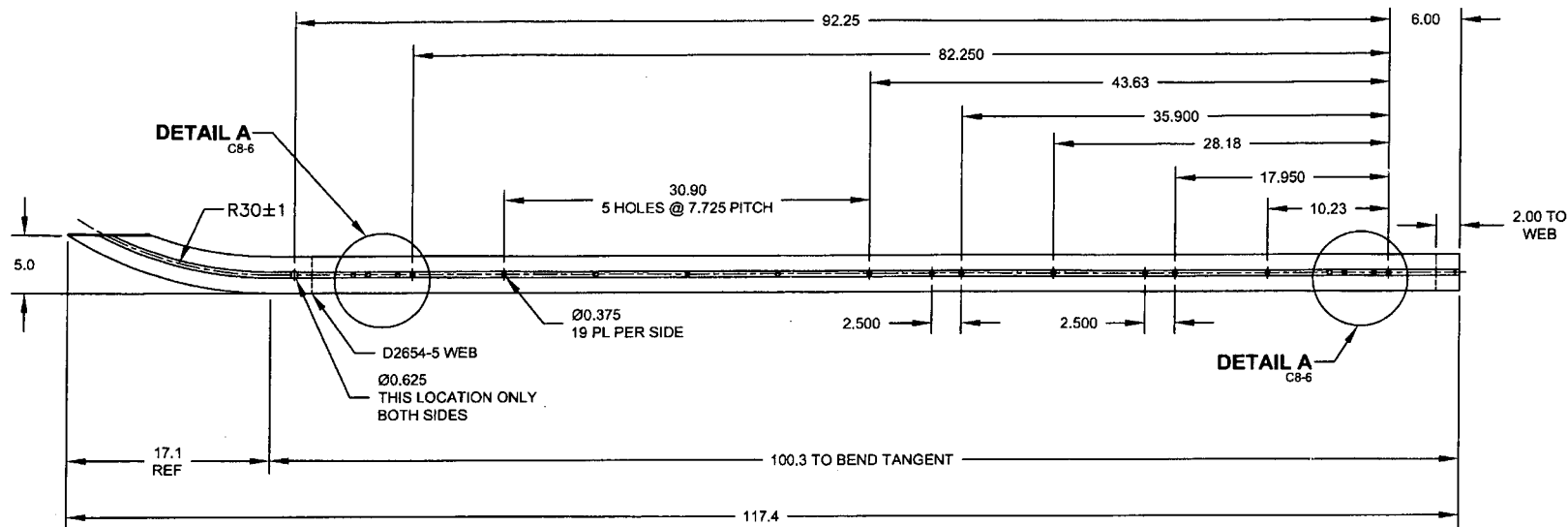
D2650-3 BENDING/DRILLING DETAIL

72784

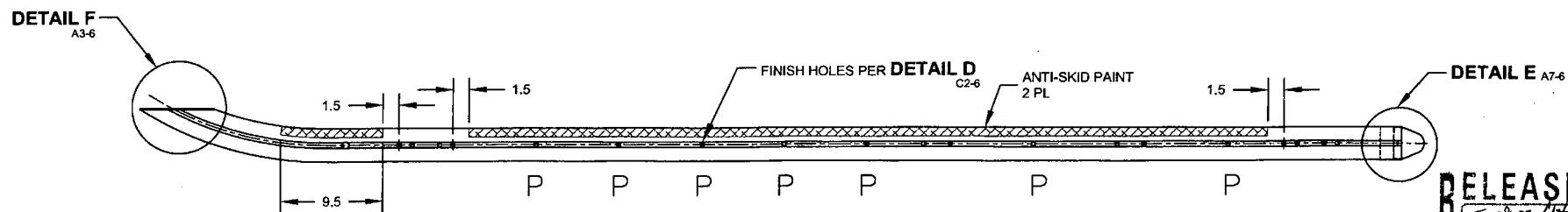


D2650-3 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
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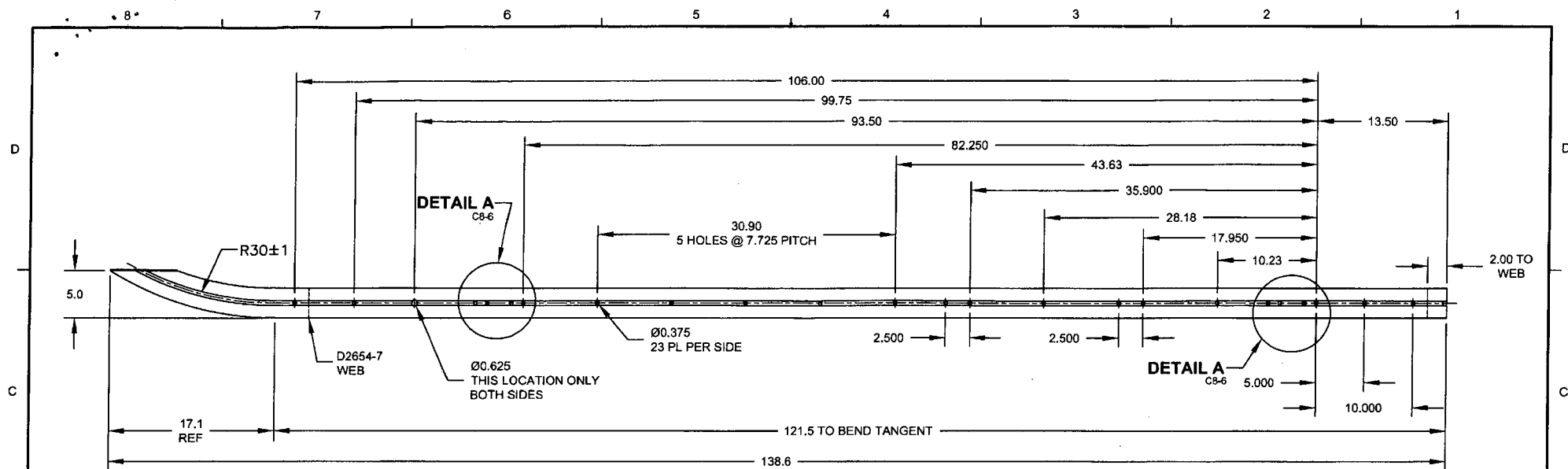
D2650-5 BENDING/DRILLING DETAIL



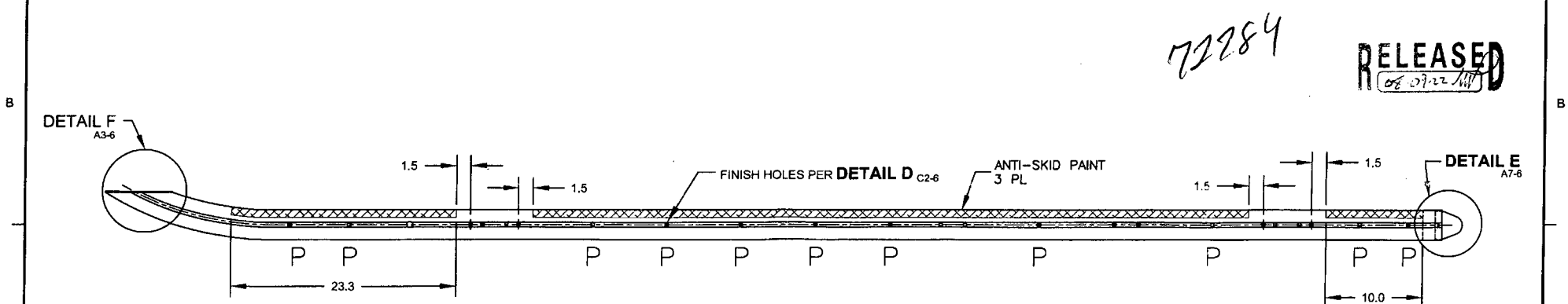
D2650-5 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
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CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	E	D2650	SHEET 4 OF 6
APPROVED	AP	TITLE	SCALE
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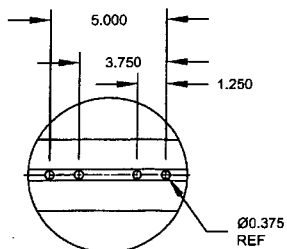
D2650-7 BENDING/DRILL DETAIL



D2650-7 ASSEMBLY/FINISHING DETAIL

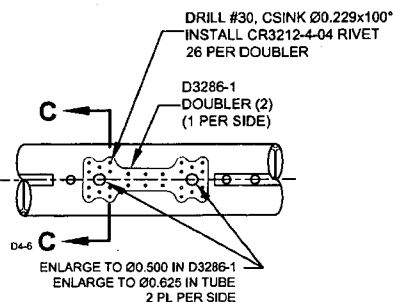
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DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 5 OF 6
APPROVED		TITLE	SCALE
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72284
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08 07 22 111



DETAIL A
SCALE 2X

C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5



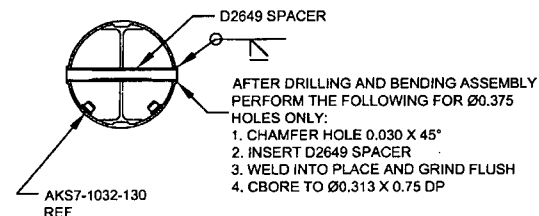
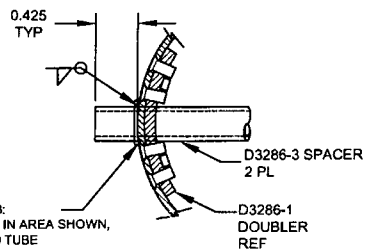
DETAIL B
SCALE 2X

C3-2
C3-3

- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.

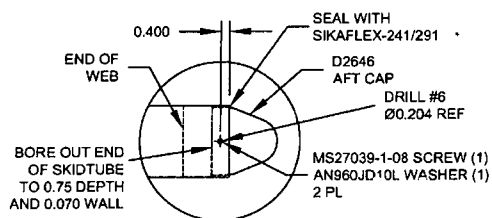


SECTION C-C C7-6
SCALE NONE



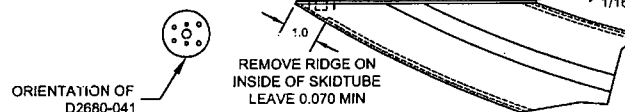
DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X

B4-2
B4-3
B4-4
B4-5



DETAIL E
SCALE 2X

B2-2
B2-3
B1-4
B1-5



DETAIL F
SCALE NONE

B8-2
B8-3
B8-4
B8-5

DETAIL F NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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DESIGN	DS	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
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NO. 273

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 74236
Part number: D206 642 151
Description: 206 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Sal. Lunn Date of Test Coupon 11-10-25
Welder Barclay Elliott Date of Test Coupon 11-10-25

The above named individual is qualified in accordance with AWS D17.1.2001 to weld